

Work Order ID 76809

76809

Page 1

Monday, November 21, 2011 11:31:31 AM

Item ID: D2661-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 11/21/2011 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: 11 Date: 11-21 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

BA 12/01/02

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number
 MACHINE AS PER DWG AND FOLIO FB073

SL 12-01-03

FOLIO REV: AA
 DWG REV: E

(10)

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

SL 12-01-03

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

LO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

10XØ M-L 12/01/05

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 Start Date: 11/21/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:40	OVEN TEMPERATURE:							
	FINISH TIME: 3:10								
	3200F								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging	Memo	0.00							
Packaging									

10X2 M-12/01/05

10 BR 12-1-6.

12/1/6 J 100

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Picklist Print

Monday, November 21, 2011 11:31:35 AM

Page 1

Work Order ID: 76809

76809

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 12/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	10			

D6101-003

Saddle Billet, 7075

B. 12/01/02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	105	
72226	8	
73775	36	
73780	7	
74650	54	
MAT44	29	
72226	2	
73769	1	
74680	26	

→ 76837

10.0

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DART AEROSPACE LTD	Work Order: 76809
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.126	.126	.128	-.129	-.126	
B	0.100	0.140		-.121	-.121	-.119	-.120	-.120	
C	1.125	1.145		1.135	1.137	1.134	1.133	1.135	
D	0.615	0.685		-.685	-.685	-.685	-.685	-.685	
E	0.240	0.260		-.252	-.251	-.251	-.252	-.250	
F	1.313	1.343		1.324	1.324	1.324	1.324	1.324	
G	0.210	0.230		-.224	-.225	-.222	-.222	-.221	
H	0.100	0.180		-.140	-.140	-.140	-.140	-.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.575	1.577	1.575	1.573	1.575	
K	0.235	0.240		-.237	-.237	-.237	-.237	-.237	
L	0.100	0.120		-.112	-.112	-.112	-.111	-.112	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		-.512	-.512	-.512	-.512	-.512	
O	5.990	6.010		5.999	5.999	5.999	5.999	5.999	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		-.314	-.314	-.314	-.314	-.314	
S	0.315	0.322		-.316	-.316	-.316	-.316	-.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		-.799	-.797	-.796	-.797	-.797	
W	0.540	0.560		-.549	-.547	-.547	-.549	-.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		-.257	-.257	-.257	-.257	-.257	
Z	0.912	0.932		-.920	-.922	-.922	-.922	-.921	
AA	0.490	0.510		-.500	-.500	-.500	-.501	-.500	
AB	0.178	0.198		-.188	-.188	-.188	-.188	-.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SL	Audited by: SL / SA
Date: 12-01-03	Date: 12/6/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

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Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

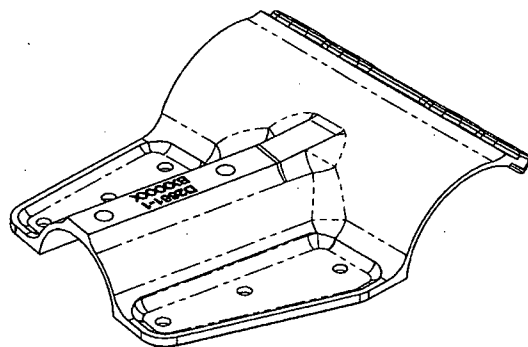
Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				1/6	2/4	3/8	4/9	By 10	
A	0.100	0.140		.128	.128	.126	.129	.128	
B	0.100	0.140		.120	.120	.120	.120	.121	
C	1.125	1.145		1.133	1.134	1.136	1.135	1.135	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.252	.250	.250	.250	.250	
F	1.313	1.343		1.323	1.323	1.324	1.324	1.324	
G	0.210	0.230		.221	.221	.222	.222	.222	
H	0.100	0.180		.140	.140	.140	.140	.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.573	1.574	1.576	1.575	1.575	
K	0.235	0.240		.237	.237	.237	.237	.237	
L	0.100	0.120		.111	.112	.112	.112	.112	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		5.999	5.999	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.314	.314	.314	.314	.314	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.798	.797	.797	.797	.797	
W	0.540	0.560		.550	.550	.550	.550	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.919	.920	.922	.921	.920	
AA	0.490	0.510		.499	.500	.501	.502	.500	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

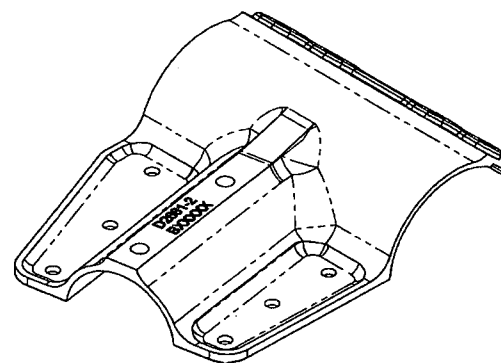
Measured by:	SL
Date:	12-01-03

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Date:	12/01/03

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C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

SHOP COPY
RETURN TO
UNCOMPLETED
SUBJECT
WORK
NO. 76807

2/11/21

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4).	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9085	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

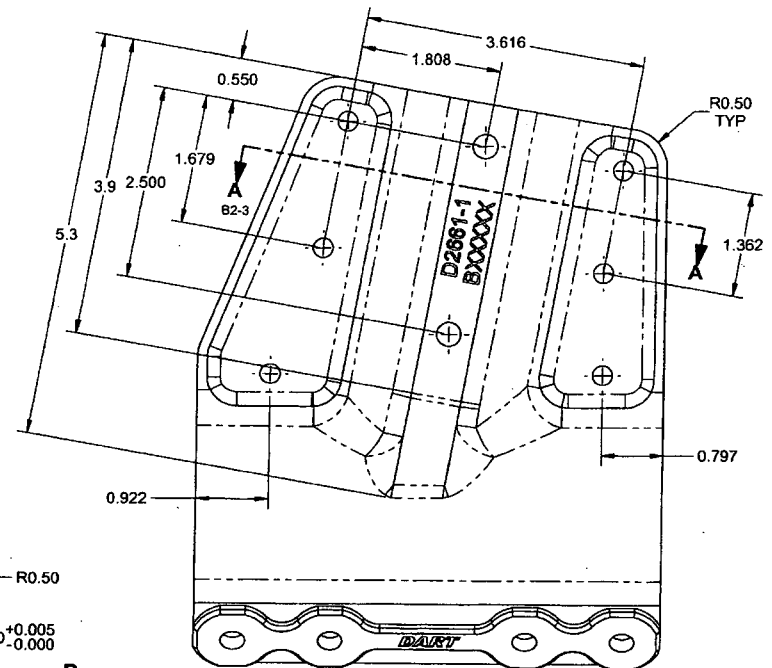
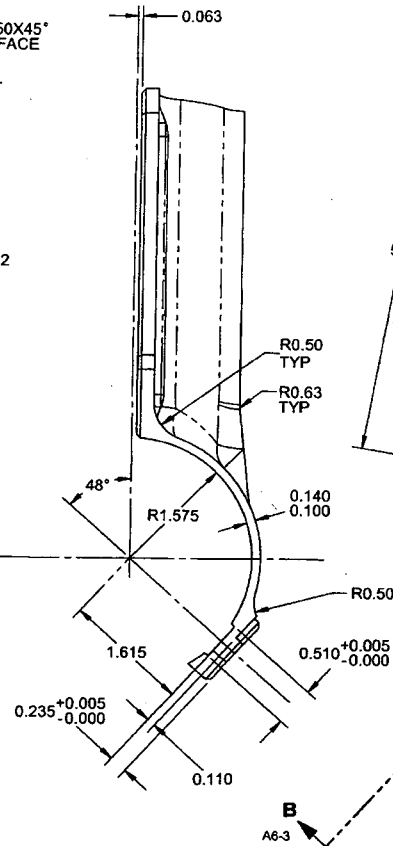
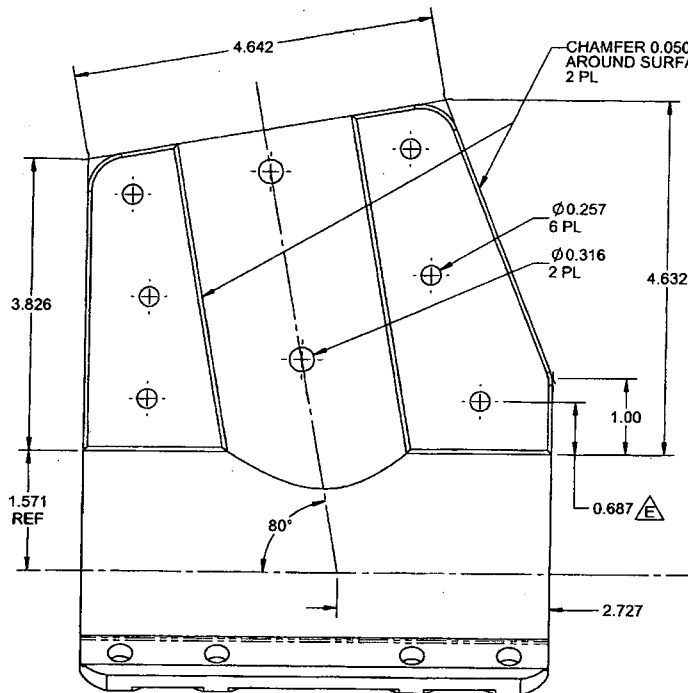
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D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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RELEASED
2011-11-16

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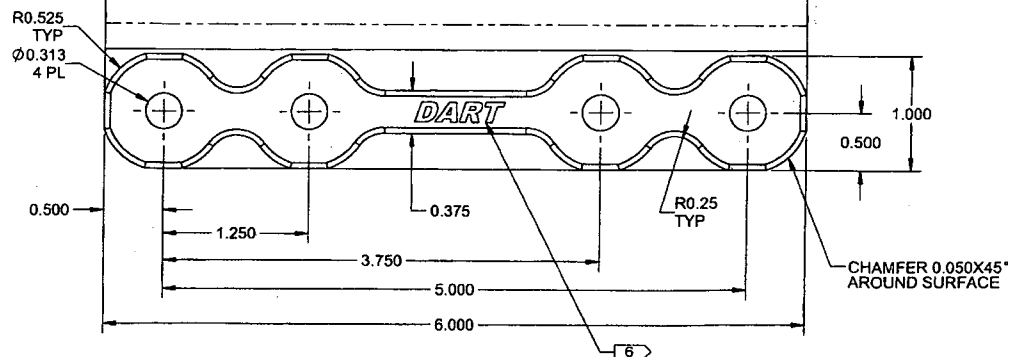
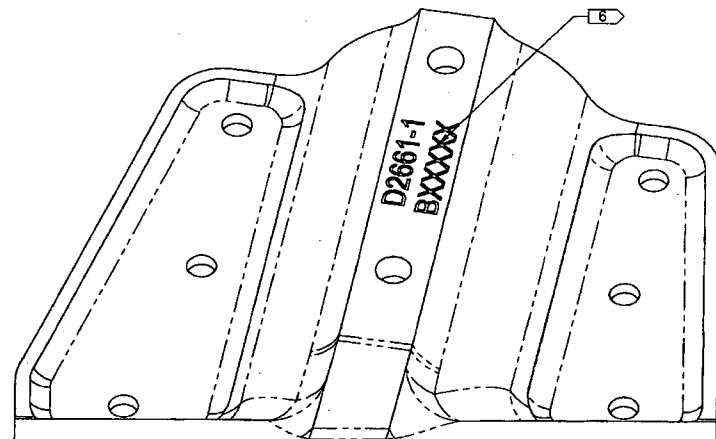
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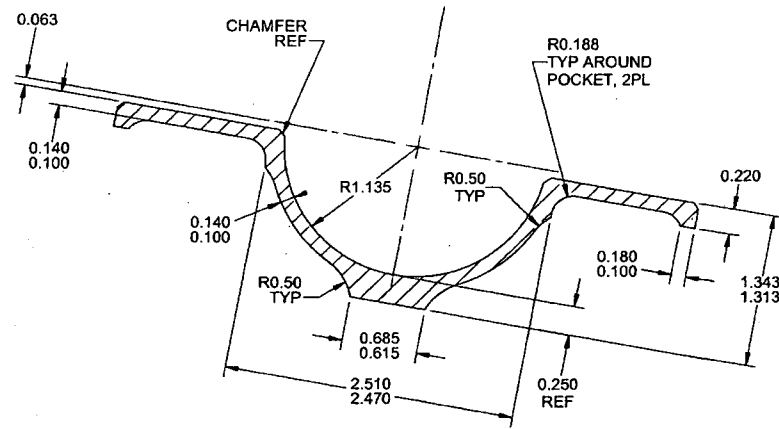
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



VIEW B-B
SCALE 1.5X
VIEW ROTATED



VIEW A-A
SCALE 1.5X

76809

RELEASED
R 2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	AS	KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED	JMS	TITLE	SCALE
DE APPR.	#	SADDLE, OUTSIDE	NTS
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8 7 6 5 4 3 2 1

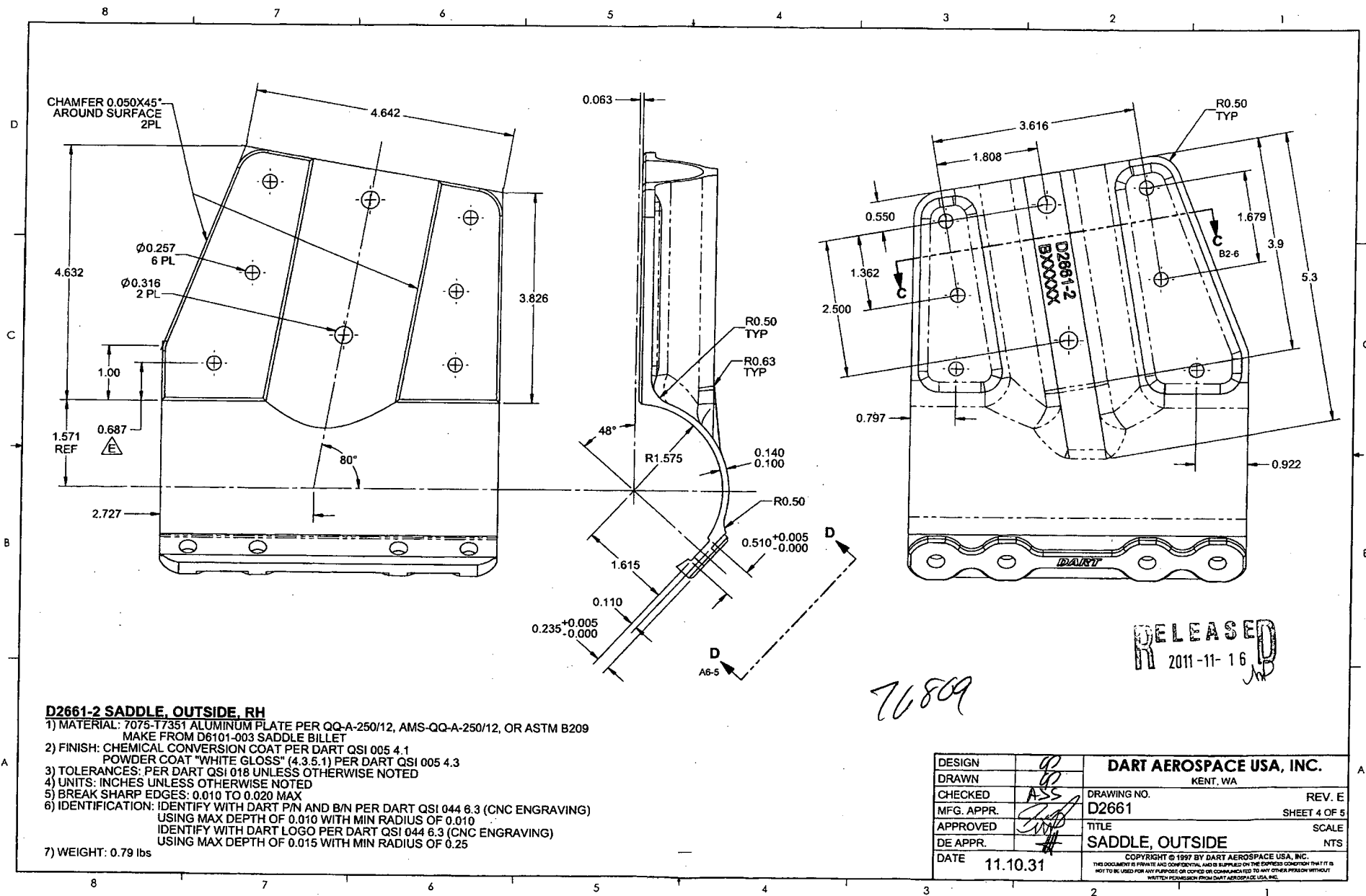
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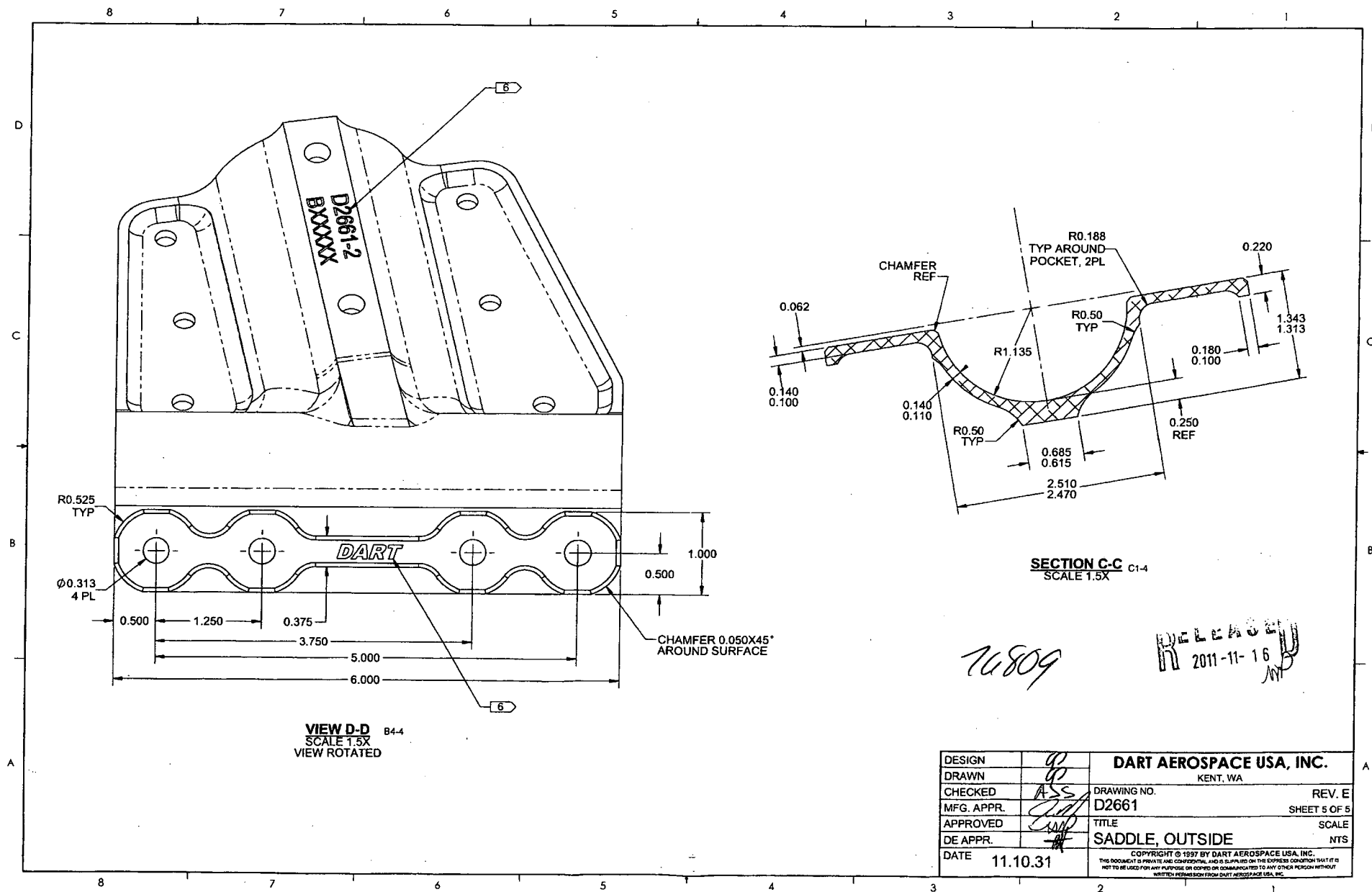
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